

Date: Wednesday, 29/10/2008 10:10:59 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number	: 43061		
Estimate Number	: 13435		
P.O. Number	:	Part Number	: PB674300111
This Issue	: 29/10/2008 S.O. No. :	Drawing Number	: B6743001 P.8
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 41365	Material	:
Written By	:	Due Date	: 05/11/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 08-10-29</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001247	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube

batch: B43072

Pl 08.11.20

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube Bushing

batch: B42069 41877

Pl 08.11.20

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: 41492

MF 08-11-14

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: 41493

MF 08-11-14

5.0	PB674300167	PB67-43001-67
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-67

batch: 41214

MF 08-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

37 08.11.20.

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/21 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/21 (X1)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HELICAL INSERT

B# M17935

SAD 08-11-27 (1)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

SAD 08-11-27 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/27

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

n/n S 08/11/27

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 102316

(1X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M-1 08/11/20/01

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 43061

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9⁻¹⁰
320⁰⁵
9=40

M-1

08/12/01

(18)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

08/12/01

(1)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

90 Degree Cover Plate

batch: 041511

FL

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PB67-43001-83

batch: 041516

FL

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch: 109031

FL

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: 109031

FL

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

FL

08/12/01

(1)

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 08 12 01

(1)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *finishing*

FL 08/12/01

(2)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/02

Job Completion



MF 08-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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